



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3407-9
Job Sheet 198617



Part No: D3407-9

Job Qty: 6 pcs

Part Name: Stem



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Due Date: 9/9/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	6 pcs	9/9/19	9/9/19	1.00	2.41	Doosan - 1		19/08/25
110	QC 2	6 pcs	9/9/19	9/9/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		19/08/25

DAS
65
9-89

DAS
65
9-89

120 QC 8	6 pcs	9/9/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	manl 12/06/07
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Packaging 3-1 - Stock - B4B	6 pcs	9/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	NL. WACO!
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	6 pcs	9/9/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1-Turn as per Folio FB572 Rev: <u>AA</u> & Dwg D3407 Rev: <u>A</u> Mill slot width at max tolerance .260" 2-Deburr					
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)					
120 - (QC8- Inspect parts - second check)					
130 - (Identify as per dwg & Stock Location: _____), LOCATION: WA001					
140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H900-R0.750	17-4 SS H900 Round Bar 0.750"	2.6400 ft (.44 ea)	100-Doosan - 1	S207999	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M17-4-H900-R0.750	3	0	0	
Part Specifications					
Specifications could not be found.					

Plex 7/31/19 1:14 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	198617
Description: Stem		Part Number:	D3407-39
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.060	✓		Vern+calc	Fm-04 / 1/428 Not
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	✓		micrometer-wires	Fm-01
Major Ø	Max: 0.249 Min: 0.2425	.2466	✓		"	"
Ø0.625	+/-0.010	.625	✓		Vernier	Fm-04
Ø0.363	+/-0.010	.370	✓		"	" Not listed in Drawing
Ø0.750	+/-0.010	.749	✓		"	"
R0.100	+/-0.010	R.1	✓		Calc	
0.470	+/-0.010	.471	✓		Vernier	Fm-04
0.250	+/-0.010	.258	✓		"	"
3.100 2.555	+/-0.010	3.100	✓		Fm04-Vernier	
4.100 3.305	+0.000/-0.010	4.098	✓		"	"
5.120 4.325	+/-0.010	5.125	✓		"	"
0.150	+/-0.010	.156	✓		"	"
0.550	+/-0.010	.556	✓		"	"
0.625	+/-0.010	.629	✓		"	"
0.250	+0.010/-0.000	.258	✓		"	"
500 ±.010		.502	✓		"	"

Measured by: JBN	Audited by: MML	Prototype Approval:	N/A
Date: 19/08/26	Date: 19/08/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	

NCR No.

Job: _____
Part No. _____

Date : _____

Sequence #:

QTY Affected :

MRB (QS042)

DISPOSITION

DEPARTMENT/PROCESS

Skid-tube
Machining
Large Fab

Cross tube
Small Fab
Finishing

Eng. (Non-AW)
Prod. Eng. Coord.
Rec/Store/Packaging

Engineering
Water Jet
Supplier
Quality

Description Work Order Deviation

Disposition

Root Cause

FAULT CATEGORY

Operator
Manufacturing Process
Equip/Tooling
Handling/Presservation
Material
Product Improvement
Process Improvement
Human Factors

Pressure/Forced
Bending
Crushing
Cracks
Crimp/Kink/Ripple/Wave/Twist
Marks/Chatter
Mislabeled
Other/Details:

Contamination
Misaligned/off center
BOM/Route
Broken/Damage/Defect
Incomplete/Unclear Instructions
Drill Holes
Fit/Function

Power Loss/Surge
Folio/Program
Grain Direction
Weld
Wrong Stock Pulled
Out of Sequence
Off-set/Set-up

Positioned Wrong
Outside Tolerance
Drawing
Finish
Part Lost/Missing
Misread

Completed By

Lead hand / Supervisor

QC / QA Coordinator